

Date: Wednesday, 18/02/2009 3:19:28 PM
User: Jean-Luc Menard

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	44683		
Estimate Number :	13130		
P.O. Number :		Part Number :	D36871
This Issue :	18/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3687 REV B
First Issue :	12/01/2009	Project Number :	N/A
Previous Run :	36808	Drawing Revision :	B
		Material :	
Written By :		Due Date :	23/02/2009
Checked & Approved By :	Qty: 6 Um: Each		
Comment :	: Est Rev:A New Issue 08-01-15 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting ship mat'l to Metcor
P.O. 7972 8148 C209/02/05.

M174B3937X4750 for heat treating
to condition H900 (to become M174PHH900B3937X4750)
FTU in excess of 190ksi
FTY in excess of 170ksi
certificate required

2.0	PG	PURCHASING
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(PD) >

Comment: PURCHASING

Issue P/O for D3687-3P P.O. 7972 C209/01/14 (6)
Machine as per Dwg D3687 Rev. B
Possible Supplier: Globus Precision
Conformity sheet required
Ship to supplier:
M174PHH900B3937X4750 B m110875.

3.0	M174B3937X4750	17-4 SS Bar 3.937 x 4.750
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Comment: Qty.: 0.3500 f(s)/Unit Total : 2.0998 f(s)
17-4 SS Bar 3.937 x 4.750

4.0	D3687P	MOUNT
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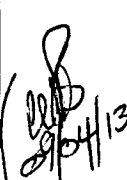

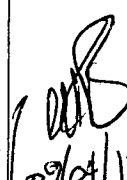


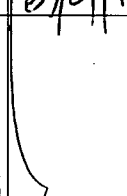

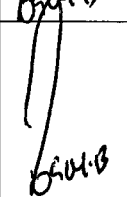
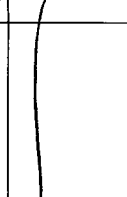


Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
MOUNT

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3687-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/05/08
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44683</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.04.08	2	Small nick in one corner FROM MACHINING PASS.		SCRAP PART. WILL LOOK LIKE DAMAGE WHEN INSTALLED, MAY CAUSE ISSUE W/ OPERATOR UP 09.04.08		S 09/04/14		S 9/4/8
09.04.08	2	THICKNESS IS 0.136 AT ONE LOCATION ON BASE. Qty (1)		SCRAP. PART. NO DEVIATION THAT WEAKENS PART PERMISSABLE. UP 09.04.08		S 09/04/14		S 9/4/8
09.04.08	2	1 part was found with the 0.189" hole measuring 0.201".		SCRAP part qty 1 Inform Globus Precision of scrap parts to have a credit issued. not yet replacements.		S 09/04/14		S 9/4/8

NOTE: Date & initial all entries

All parts are donated
to Eng - marketing for show
stuff.

S
09/04/14

Date: Wednesday, 18/02/2009 3:19:28 PM

User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44683

Part Number: D36871

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

PC 9/4/3

(3)

6.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/04/14 (x3)

7.0 OUTSIDE SERV.30 OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES-MACH

Issue P/O: 8579

LPI Per ASTM 1417 LEVEL 2

Certificate of conformaty is required

C 209/04/17 (3)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RECEIVE AND INSPECT FOR TRANSIT

DAMAGE

ENSURE C OF C ATTACHED

PC 9/4/14 (3)

9.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/04/14 (x3)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 9/5/10 (3)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



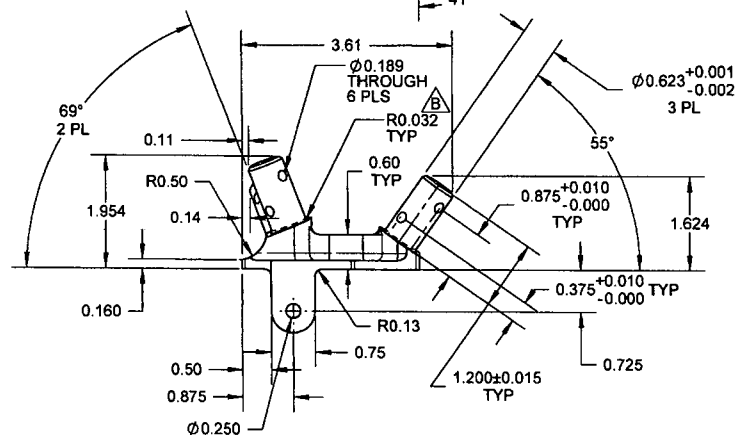
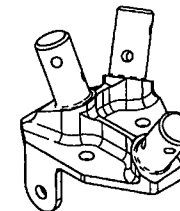
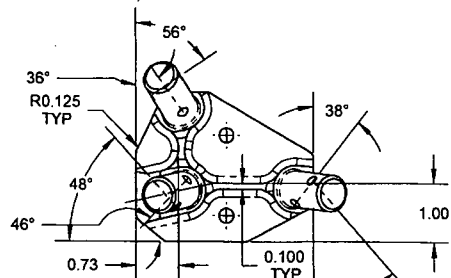
Comment: FINAL INSPECTION/W/O RELEASE

09/05/10

Job Completion

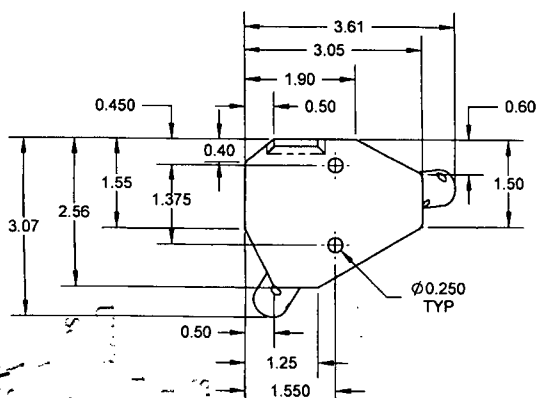


MF 09-05-07



D3687-1 MOUNT

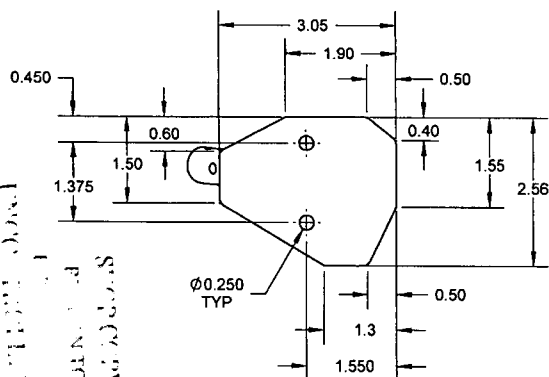
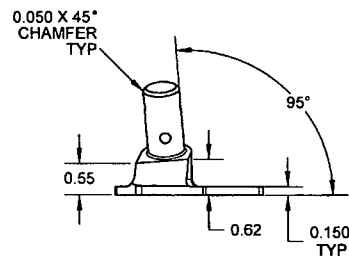
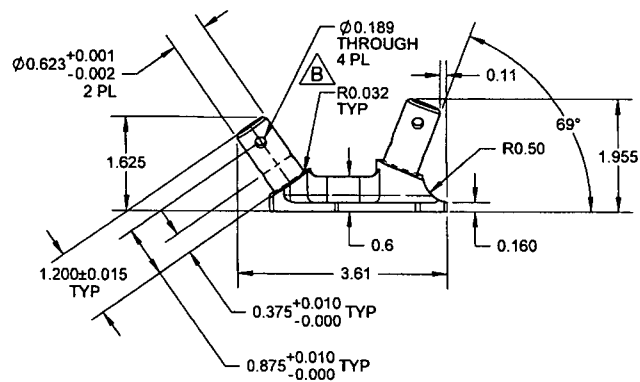
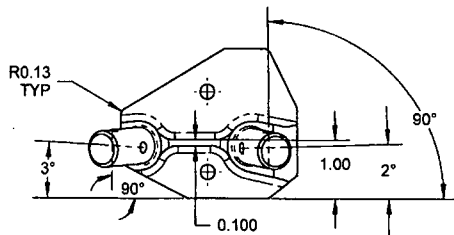
RELEASED
08/12/15



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3687 REV. B SHEET 1 OF 2 TITLE MOUNT SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	08.11.24		





NO. 141083



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

D3687-3 MOUNT

RELEASED
08/12/15

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3687	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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NO 441083

RECEIVED
DART AEROSPACE LTD
HAWKESBURY, ONTARIO
CANADA
08/12/15



Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
3/30/2009	17517

BILL TO			SHIP TO		
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7			Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7		
P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
00007972	Net 30 Days	3/30/2009	FedEx	902	Globus
QTY	DESCRIPTION				
6	D36871P Rev. B Mount Business Number: 102122058 <i>if only 4 pots are available.</i>				
<p>MANUFACTURED IN ACCORDANCE WITH DRAWINGS AND PURCHASE ORDER SPECIFICATIONS</p> <p><i>[Signature]</i></p>					

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts



LIQUID PENETRANT TEST REPORT

P- 15005

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE APR 16 09 TIME AM ☒ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-09-1375
ADDRESS 1270 ABERDEEN PO/WO NO. _____
HAWKESBURY, ONT. WORK LOCATION HAWKESBURY ONT
ACCEPTANCE STD. ASTM 1417 REV./DATE _____
PROJECT _____
ITEM(S) EXAMINED X TUBES + BRACKETS

JOB DESCRIPTION _____ PROCEDURE NO. LT-~~XX~~Z REV./DATE 20 APR 07 TECHNIQUE NO. LT-~~XX~~Z REV./DATE 2007
PART NO. _____ MATERIAL ALUM/SS. THICKNESS _____
SCOPE FLPI ON 100% EXTERNAL SURFACE.

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 1081 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT ZL67 MINIMUM DWELL TIME 45 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H₂O MINIMUM DRY TIME >10 MIN. OTHER _____
DEVELOPER ZP9F MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N _____ CAL DUE DATE MAY 24 09
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < - 4°C/ 20°F ☐ - 4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☒ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

	COMMENTS	ACCEPT	REJECT
JOB 44683	PIN D36871-3 BRACKETS		
47147	D212664101 212/205 HIGH FWD X TUBE		
47150	" " " " " "		
46812	D407667105 407 FWD X TUBE		
46813	" " " " " "		
46814	D407667205 407 HIGH AFT X TUBE		
NO INDICATIONS OF DEFECTS ITEMS ACCEPTABLE TO CODE			

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE [Signature] DTR # E27432
TECHNICIAN (SIGNATURE): [Signature] SIGNATURE _____
NAME (PRINT): J. HOWETT REPORT REVIEWED BY: _____
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL _____ SNT LEVEL _____
CGSB REG. NO. 6156 CGSB REG. NO. _____



PRECISION INC.

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

RECEIVED APR 27 2009

Credit Memo

DATE	CREDIT NO.
4/20/2009	17542

CUSTOMER

Dart Aerospace
1270 Aberdeen Street
Hawksbury, Ontario
K6A 1K7

P.O. NO.
00007972

DESCRIPTION	QTY	RATE	AMOUNT
D36871P Rev. B Mount	-3	400.00	-1,200.00T
NOTE: Parts submitted for approval - rejected by Dart. Original invoice 17517 dated March 30/09			
Total GST			-60.00
Business Number: 102122058			
Total			-\$1,260.00